

Work Order ID 84191

84191

Page 1

May-07-12 11:20:26 AM

Item ID: D4148-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Crosstube Lug Assembly, Fwd

Start Date: 07/05/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 23/05/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/07 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D4148

D

100

0.00

100

Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

120

Identify as per dwg & Stock Location ST 468 0.00

120

Packaging

Memo

0.00

Packaging

6 12/05/07

6 12/05/07

6x 12-5-30

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

84191

Page 2

N900040100

Setup Start *NS1*

Stop ***NS2***

6

6

Reference:

Run Start *NR1*


Stop *NR2*

| Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|------------|------------|---------------|-------------|
|------------|------------|---------------|-------------|

0.00

0.00

Quality Control

Number Stamp
12/5/30 
mf
12-05-30

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

May-07-12 11:20:45 AM

Page 1

Work Order ID: 84191

84191

Parent Item: D4148-041

D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 07/05/2012

Required Date: 23/05/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC

IPP Rev:B 10.07.22 as per revB DD verf:JLM

10.10.29 as per revC DD verf:EC

AS PER DWG REV.D DD VERF:EC

IPP Rev:C

IPP REV:D 11.03.02

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

MS21043-3

Purchased

No

100

Each

1,001.000

4

12

MS21043-3

**

Nut

Location

Loc Qty

Loc Code

FG

72

103691

72

GA

88

120693

88

ST301

841

118077

2

118614

59

118686

30

119758

20

121255

730

MS21043-4

Purchased

No

100

Each

1,729.000

1

18

MS21043-4

**

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1689

119546

201

121162

988

121652

500

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Picklist Print

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Page 2

Work Order ID: 84191

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Parent Item: D4148-041

D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 07/05/2012

Required Date: 23/05/2012

Start Qty: 6.00

Required Qty: 6.00

D2690-6

Manufactured No

100

Each

35.0000

1

6

D2690-6

Lanyard Assembly

**

Location

Loc Qty

Loc Code

ST014

20

83360

20

ST016

15

83691

15

D3910-1

Manufactured No

100

Each

41.0000

1

6

D3910-1

Crosstube Lug

**

Location

Loc Qty

Loc Code

st507

41

81474

2

81573

39

D4091-1

Manufactured No

100

Each

80.0000

1

6

D4091-1

Mounting Lug

**

Location

Loc Qty

Loc Code

ST458

80

81168

30

81461

10

81575

40

D4148-1

Manufactured No

100

Each

30.0000

2

12

D4148-1

Crosstube Lug Plate, Fwd

**

Location

Loc Qty

Loc Code

ST132

30

82046

3

82964

12

83421

15

May-07-12 11:20:45 AM

Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
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Picklist Print

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Page 3

Work Order ID: 84191

84191

Parent Item: D4148-041

D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 07/05/2012

Required Date: 23/05/2012

Start Qty: 6.00

Required Qty: 6.00

D4148-3 Manufactured No

100 Each

18.0000

1 6

D4148-3

Stud Receiver, Lower

**

Location

Loc Qty

Loc Code

ST133

18

82311

6

83356

12

D4148-5 Manufactured No

100 Each

11.0000

1 6

D4148-5

Eyebolt Stud

**

Location

Loc Qty

Loc Code

ST133

11

82965

11

AN3C12A Purchased No

100 Each

247.0000

2 12

AN3C12A

Bolts

**

Location

Loc Qty

Loc Code

GA

40

120449

40

ST351

207

117514

4

118112

5

118451

22

119510

1

120423

125

121584

50

Handwritten signatures and dates:
 12/05/2012
 12/05/2012
 12/05/2012
 12

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Picklist Print

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Page 4

Work Order ID: 84191

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

84191

D4148-041

Start Date: 07/05/2012

Required Date: 23/05/2012

Start Qty: 6.00

Required Qty: 6.00

AN4C13A

Purchased

No

100

Each

78.0000

3

18

AN4C13A

BOLT

**

Location

Loc Qty

Loc Code

ST357

78

120187

1

120423

2

121444

50

121556

25

MS17984-C413

Purchased

No

100

Each

32.0000

1

6

MS17984-C413

PIN, QUICK RELEASE

**

Location

Loc Qty

Loc Code

ST315

3

114340

1

118612

2

ST333

20

121350

20

ST335

9

121091

9

MS20615-4M18

Purchased

No

100

Each

204.0000

8

48

MS20615-4M18

Rivet

**

Location

Loc Qty

Loc Code

322

100

121349

100

ST322

50

121444

50

ST323

54

118543

54

May-07-12 11:20:46 AM

Shop Packet Print

Page 4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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| | | | | | | | |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

May-07-12 11:20:46 AM

Page 5

Work Order ID: 84191

84191

Parent Item: D4148-041

D4148-041


Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 07/05/2012

Required Date: 23/05/2012

Start Qty: 6.00

Required Qty: 6.00

 NAS1149C0332R Purchased No
NAS1149C0332R
 Washer

No

100

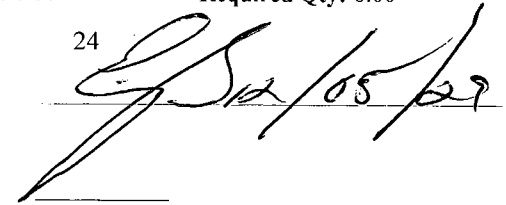
Each

4,550.000

4

24

**

 05/05/12

Location

Loc Qty

Loc Code

ST297

219

119736

196

120648

23

ST298

4331

121255

31

121509

4300

~~16~~
8

NAS1149C0432R

Purchased

No

100

Each

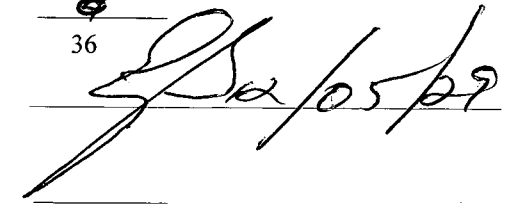
4,488.000

6

36

**

NAS1149C0432R
 Washer

 05/05/12

Location

Loc Qty

Loc Code

ST297

1524

117291

524

119124

1000

ST298

2964

121255

2964

36

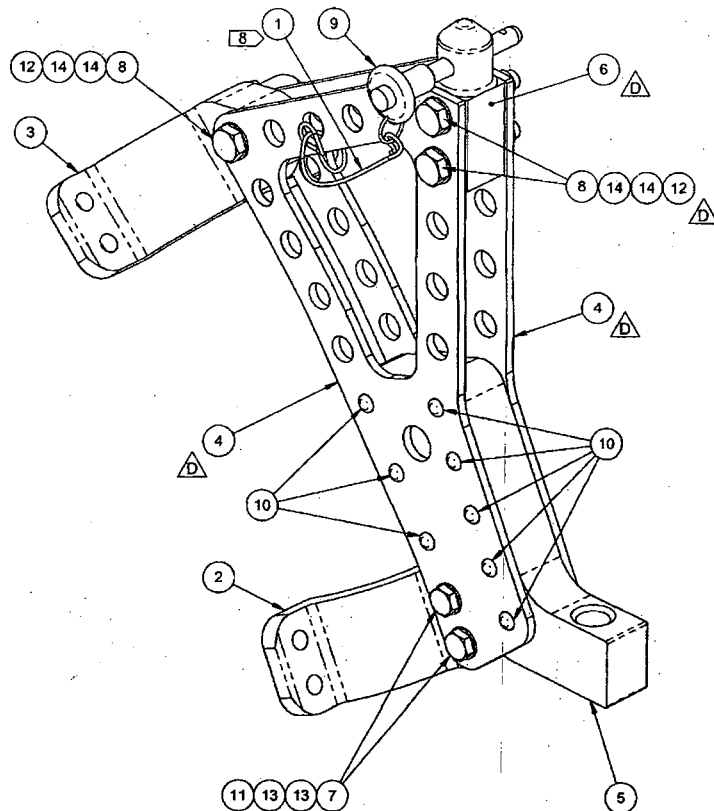
| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries



D4148-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" PER DART QSI 044 6.1
- 7) WEIGHT: 3.67 lbs
- 8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 84191 MLC
12/05/07

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|---------------|----------------------|
| | X | D4148-041 | FWD X-TUBE LUG ASSY |
| 1 | 1 | D2690-6 | LANYARD |
| 2 | 1 | D3910-1 | X-TUBE LUG |
| 3 | 1 | D4091-1 | MOUNTING LUG |
| 4 | 2 | D4148-1 | FWD X-TUBE LUG PLATE |
| 5 | 1 | D4148-3 | STUD RECEIVER LOWER |
| 6 | 1 | D4148-5 | EYEBOLT STUD |
| 7 | 2 | AN3C12A | BOLT |
| 8 | 3 | AN4C13A | BOLT |
| 9 | 1 | MS17984-C413 | PIP PIN |
| 10 | 8 | MS20615-4M18 | RIVET |
| 11 | 2 | MS21043C3 | NUT |
| 12 | 3 | MS21043C4 | NUT |
| 13 | 4 | NAS1149C0332R | WASHER |
| 14 | 6 | NAS1149C0432R | WASHER |

RELEASED
2011-02-24

| D | HOLE DIA CHANGED TO 0.252" (D8-3); HOLE DIA CHANGED TO 0.260" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C3 AND QTY(4) NAS1149C0432R (D3-1, C4-2) | SC | 11.02.22 |
|------------|---|----|----------|
| C | REDESIGNED D4148-1/3 TO ADDRESS COMPATIBILITY ISSUES WITH D350-591 SHORT STEPS | MB | 10.10.12 |
| B | REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); Ø 0.191 2 PL REPLACES Ø 0.129 3 PL (ZN D6-3); Ø 0.129 7 PL WAS 10 PL (ZN A7-3); Ø 0.191 WAS Ø 0.129 (ZN C8-5); REASON: SEE TR-D350-607-2 REV. B. | MB | 10.07.05 |
| A | NEW ISSUE | MB | 10.06.18 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | MB | | |
| DRAWN | SC | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 11.02.22 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4148** REV. D
SHEET 1 OF 5
TITLE **FWD X-TUBE LUG ASSY** SCALE NTS

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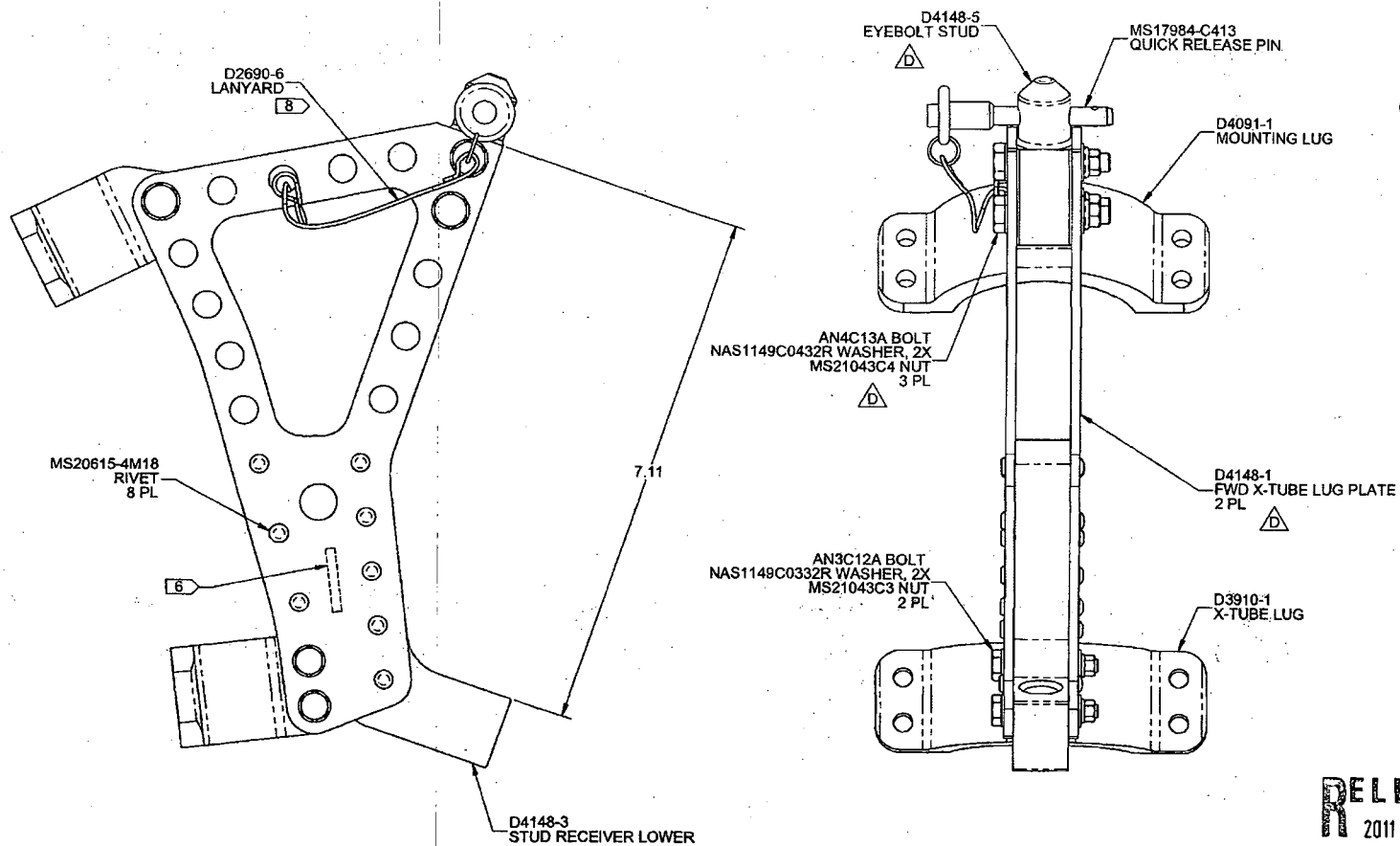
| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



84191

RELEASED
2011-02-24
JNP

D4148-041 FWD X-TUBE LUG ASSY

| | | | |
|------------|----------|---|--------------|
| DESIGN | MB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | SC | | |
| CHECKED | | DRAWING NO. D4148 | REV. D |
| MFG. APPR. | | TITLE FWD X-TUBE LUG ASSY | SHEET 2 OF 5 |
| APPROVED | | SCALE | NTS |
| DE APPR. | | COPYRIGHT © 2010 BY DART AEROSPACE LTD | |
| DATE | 11.02.22 | THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR OR REPRODUCED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

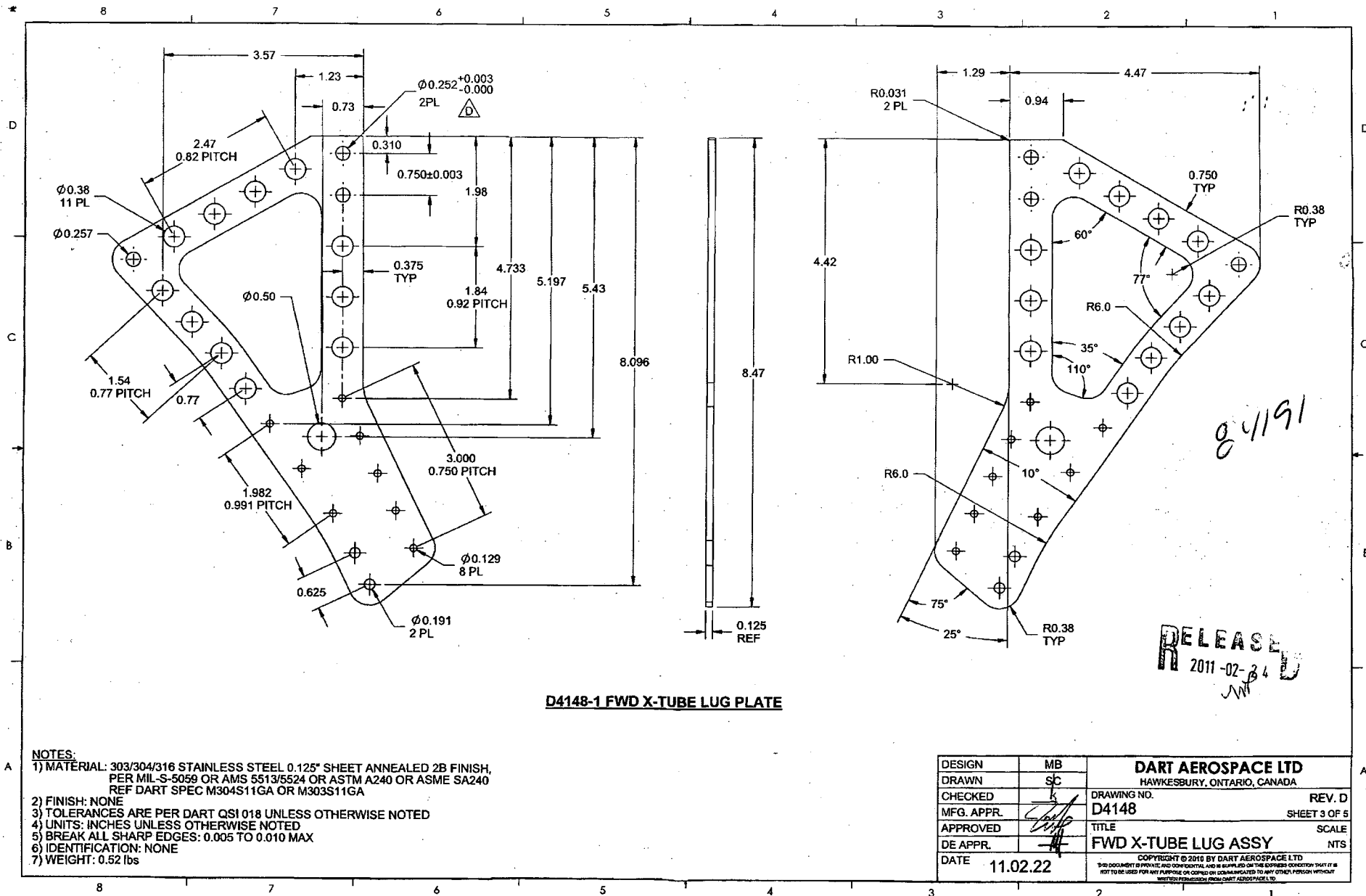
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NOTE: Date & initial all entries



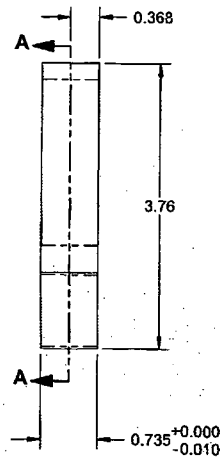
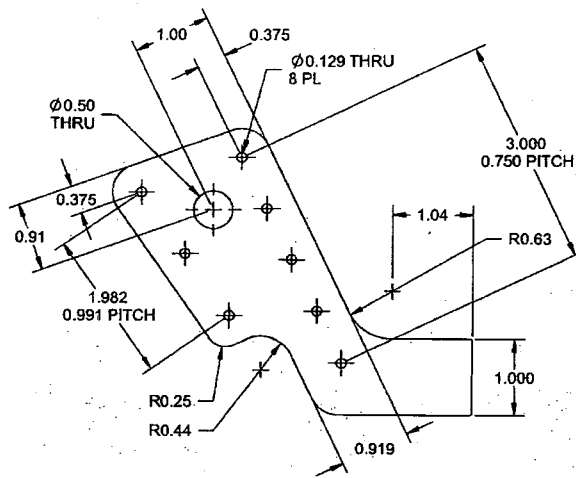
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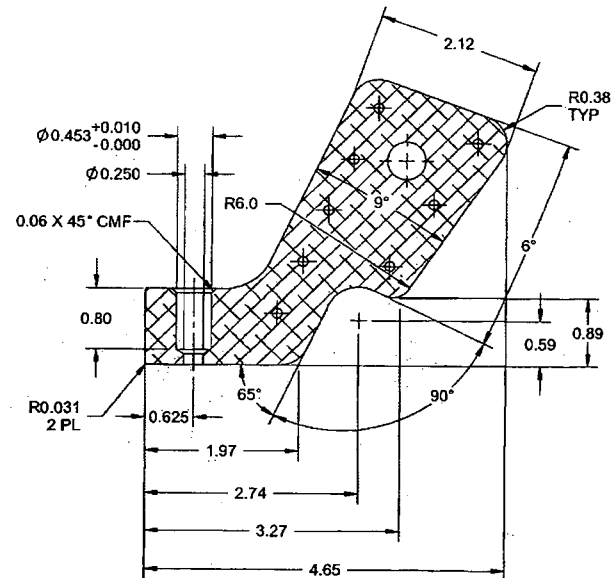
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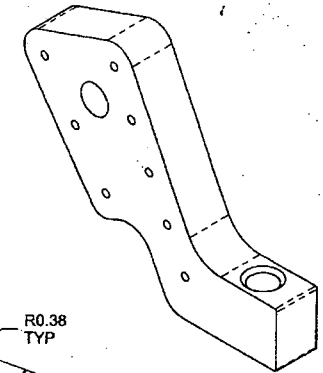
NOTE: Date & initial all entries



D4148-3 STUD RECEIVER LOWER



SECTION A-A



84191

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.52 lbs

| | | | |
|------------|----------|--|--------------|
| DESIGN | MB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | SC | | |
| CHECKED | | DRAWING NO. D4148 | REV. D |
| MFG. APPR. | | | SHEET 4 OF 6 |
| APPROVED | | TITLE FWD X-TUBE LUG ASSY | SCALE NTS |
| DE APPR. | | COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |
| DATE | 11.02.22 | | |

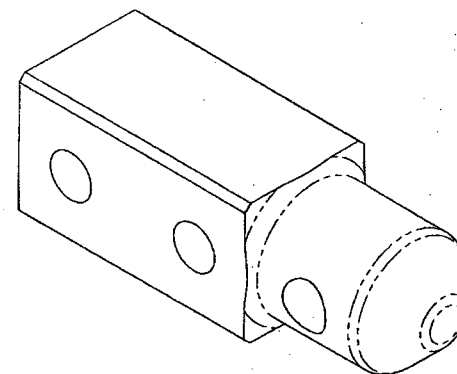
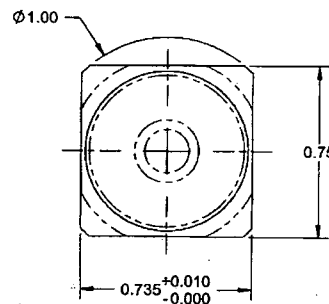
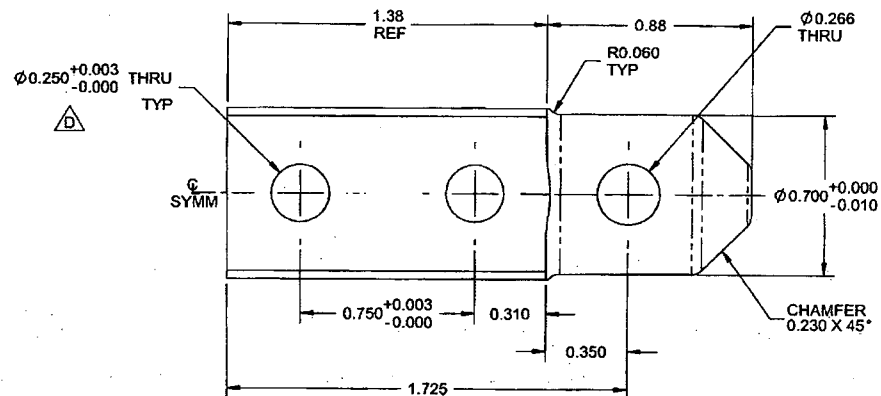
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



D4148-5 EYEBOLT STUD

RELEASED
2011-02-24
JW

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs

| | | | |
|------------|----------|---|--------|
| DESIGN | MB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | SC | | |
| CHECKED | K | DRAWING NO. D4148 | REV. D |
| MFG. APPR. | JW | SHEET 5 OF 5 | |
| APPROVED | JW | TITLE | SCALE |
| DE APPR. | JW | FWD X-TUBE LUG ASSY | NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries